

Work Order ID 67923

Page 1

Tuesday, April 05, 2011 9:57:59 AM

Item ID: D3686-041

Accept



Setup Start



Revision ID:

Stop



Item Name: MONOPOD ASSEMBLY

Start Date: 4/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3686	Rev D
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100 Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP 11/6/04

②

110 Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686
ENSURE THERE IS ANTI-SEIZE ON FULL LENGTH OF THREAD*****

SP 11/6/04

②

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686
***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3686

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

0.00 *Setup 7/04**(+2)*

QC

Memo

Quality Control

130

Identify as per dwg & Stock Location: *77*

0.00



0.00

Packaging

Memo

Packaging

11/7/5

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

*11/7/6**ME**11-07-06*

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Picklist Print

Tuesday, April 05, 2011 9:58:05 AM

Page 1

Work Order ID: 67923

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY





Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-7  STUD		Manufactured	No			110	Each	4.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>50931</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3689-1  SLEEVE		Manufactured	No			110	Each	2.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>65346</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3691-1  STUD		Manufactured	No			110	Each	24.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>61370</div> <div>62181</div> </div> <div> <div>Loc Qty</div> <div>24</div> <div>13</div> <div>11</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3692-1  SPACER		Manufactured	No			110	Each	225.0000	4	8			
<div> <div>Location</div> <div>ST075</div> <div>51467</div> </div> <div> <div>Loc Qty</div> <div>225</div> <div>225</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

SB 11/07/04 (2)

2

B69034 (2) SB 11/07/04 (2)

SB 11/07/04 (2)

2

SB 11/07/04 (2)

2

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Picklist Print

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Tuesday, April 05, 2011 9:58:05 AM

Work Order ID: 67923

Parent Item: D3686-041


Parent Item Name: MONOPOD ASSEMBLY

Start Date: 4/4/2011

Required Date: 4/8/2011


Start Qty: 2.00

Required Qty: 2.00

D3692-3	Manufactured	No	110	Each	23.0000	4	8	
								
SPACER								


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST075	23	
44690	23	8

D3693-1	Manufactured	No	110	Each	22.0000	1	2	
								
Rod End Bearing								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	22	
50734	22	2

D3693-3	Manufactured	No	110	Each	2.0000	1	2	
								
Rod End Bearing								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	2	
50723	2	2

AN3C10A	Purchased	No	110	Each	28.0000	2	4	
								
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	28	
105940	8	4
112489	20	

AN3C12A	Purchased	No	110	Each	41.0000	2	4	
								
Bolts								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	41	1117794
116924	41	

Tuesday, April 05, 2011 9:58:06 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, April 05, 2011 9:58:06 AM

Work Order ID: 67923

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-3 Purchased No 110 Each 1,072.000 4 8



Nut



SS 4/6/07/04 (2)

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP-B	16	
112314	16	
ST301	976	
112314	976	

NAS509L12C Purchased No 110 Each 33.0000 1 2



Nuts



SS 4/6/07/04 (2)

Location	Loc Qty	Loc Code
ST280	33	
112314	23	
112828	10	

NAS509-12C Purchased No 110 Each 28.0000 1 2



Nuts



SS 4/6/07/04 (2)

Location	Loc Qty	Loc Code
ST280	28	
112453	28	

2

W/O:

WORK ORDER CHANGES

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

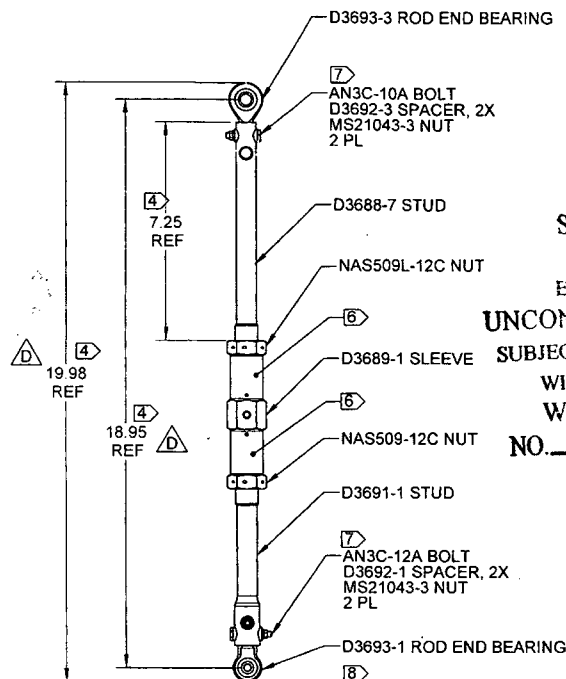
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67923
PL 1104-5

D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in.-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3686	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MONOPOD ASSEMBLY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2010-03-15
[Signature]

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